

Work Order ID 84911

May-29-12 1:07:12 PM

84911

Page 1

Item ID: D209-669-014

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Skidtube RH

Stop

NS2Start Date: 29/05/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: ML5Date: 12/05/12 Tooling:

Date:

Run

Start

NR1

QC:

Date: _____ SPC (Y/N):

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D209-669-014	Rev B								
DSI 9450	Rev A								
100		0.00	(DAS) 16 9-89	12/05/12					
100	DOCUMENT CONTROL	50							
DC									
Document Control									
110	Pick Kit	0.00							
110									
Packaging									
Packaging									

100	Pick Kit	0.00							
-----	----------	------	--	--	--	--	--	--	--

110									
--------------	--	--	--	--	--	--	--	--	--

Packaging									
-----------	--	--	--	--	--	--	--	--	--

Packaging									
-----------	--	--	--	--	--	--	--	--	--

12/05/12	SP
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84928

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B				Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Work Order ID 84911

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Page 2

Item ID: D209-669-014

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Skidtube RH

Stop

NS2Start Date: 29/05/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00	DAS 16 9-89	12/07/27					

130 *130* Packaging Packaging	Packaging Memo	0.00 0.00	<i>12/07/27</i>
	Identify and pack for shipping as per PPPD209-669-014 Location: <i>SH&P</i>		

140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00	<i>12/07/23</i>
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12/07/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

May-29-12 1:07:16 PM

Page 1

Work Order ID: 84911

84911
D209-669-014

Parent Item: D209-669-014

Parent Item Name: Skidtube RH

Start Date: 29/05/2012

Start Qty: 1.00

Required Date: 16/07/2012

Required Qty: 1.00

Comments: New IPP 08.02.13 new issue EC, verified by:DD
IPP Rev:B 08-05-20 chg QTY of D2570 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D209-669-043

Manufactured

No

110

Each

2.0000

**

84928

Replacement Skidtube

Location	Loc Qty	Loc Code
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Mezz

2

39205

1

39206

1

D2917-2

Manufactured

No

110

Each

1.0000

**

2

D2917-2

Saddle RH

Location	Loc Qty	Loc Code
----------	---------	----------

ST424

1

52129

1

D2918-2

Manufactured

No

110

Each

1.0000

**

2

D2918-2

Saddle RH

Location	Loc Qty	Loc Code
----------	---------	----------

ST424

1

52133

1

384940 12/1/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-29-12 1:07:16 PM

Page 2

Work Order ID: 84911**Parent Item:** D209-669-014**Parent Item Name:** Skidtube RH***84911***
D209-669-014**Start Date:** 29/05/2012**Start Qty:** 1.00**Required Date:** 16/07/2012**Required Qty:** 1.00

AN4-51A

Purchased

No

110

Each

302.0000

8

8

**

SF

AN4-51A

Bolt

Location Loc Qty Loc Code

362	200	
121181	200	8
ST361	102	
119798	30	
121584	72	

D2570

Manufactured

No

110

Each

711.0000

24

24

**

B85411

D2570

Bushing

Location Loc Qty Loc Code

ST011	711	
72960	41	
78586	9	
79493	12	
81956	24	
81957	400	
82874	225	

MS21042L4

Purchased

No

110

Each

4,095.000

24

24

**

12/2/12 SF

MS21042L4

Nut

Location Loc Qty Loc Code

ST300	4095	
119075	125	
121011	713	
121444	2957	24
121652	300	

W/O:		WORK ORDER CHANGES							
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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May-29-12 1:07:16 PM

Page 3

Work Order ID: 84911

84911
D209-669-014

Parent Item: D209-669-014

Parent Item Name: Skidtube RH

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN5-36A

Purchased No 110 Each 184.0000 4 4 **

AN5-36A

Bolt

Location	Loc Qty	Loc Code
340	134	
121181	34	
121652	100	
ST340	50	
121708	50	

AN960JD516

NAS1149D0563I Purchased

No 110 Each 0.0000 8 8 **

AN960JD516

Washer

MS21042L5

Purchased No 110 Each 1,447.000 4 4 **

MS21042L5

Nut

Location	Loc Qty	Loc Code
300	500	
121652	500	
ST300	947	
108827	8	
116105	5	
116548	43	
117611	18	
119109	865	
17651	8	

AN4-7A

Purchased No 110 Each 124.0000 16 16 **

AN4-7A

Bolt

Location	Loc Qty	Loc Code
ST356	124	
117514	24	
120770	100	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

May-29-12 1:07:16 PM

Page 4

Work Order ID: 84911

84911
D209-669-014

Parent Item: D209-669-014

Parent Item Name: Skidtube RH

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN960JD416 NAS1149D0463J Purchased

No 110 Each 30.0000 32 32

**

AN960.JD416

Washer

May-29-12 1:07:16 PM

D2929 *D2929*

Spacer

Manufactured No

110 Each 86.0000 2 2

**

sf

D2930 *D2930*

Spacer

Manufactured No

110 Each 102.0000 2 2

**

2

D3405-041 *D3405-041*

Lug Assembly

Manufactured No

110 Each 6.0000 1 1

**

3

735098

Location	Loc Qty	Loc Code
ST478	6	
62227	2	
77000	2	
82031	1	
82032	1	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

May-29-12 1:07:17 PM

Page 5

Work Order ID: 84911

84911
D209-669-014

Parent Item: D209-669-014

Parent Item Name: Skidtube RH

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN4C47A

Purchased No 110 Each 48.0000 4 **

AN4C47A

Bolt

Location	Loc Qty	Loc Code
ST361	48	
118451	6	
119798	2	
121009	22	
121585	18	

MS21043-4

Purchased No 110 Each 1,346.0000 5 **

MS21043-4

Nut

Location	Loc Qty	Loc Code
FG	40	
104603	40	
ST301	1306	
119546	147	
121162	659	
121652	500	

D3405-043

Manufactured No 110 Each 2.0000 1 **

D3405-043

Lug Assembly

Location	Loc Qty	Loc Code
ST478	2	
82038	2	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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May-29-12 1:07:17 PM

Page 6

Work Order ID: 84911

84911
D209-669-014

Parent Item: D209-669-014

Parent Item Name: Skidtube RH

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

D3407-041

Manufactured No

110

Each

27.0000

1

1

**

D3407-041

Tow Ring

Location	Loc Qty	Loc Code
ST463	27	
82067	6	
82068	19	
82108	2	

D3456-1

Manufactured No

110

Each

156.0000

1

1

**

D3456-1

Washer

Location	Loc Qty	Loc Code
FG	7	
25701	7	
ST044	149	
80252	1	
81876	48	
83584	100	

D3417-5

Manufactured No

110

Each

78.0000

2

2

**

D3417-5

Washer

Location	Loc Qty	Loc Code
ST042	78	
78842	28	
83318	50	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D209-669 REV. B

INSTRUCTIONS:

1) FOR D209-669-011/-012/-013/-014 SKID TUBES @ CHANGE 003 AND SUBSEQUENT, MODIFY THE FOLLOWING:

- a) REPLACE THE D2968-041 TOW RING WITH THE D3407-041 TOW RING ASSEMBLY.
- b) REPLACE THE D2736-1 AND D2736-3 GHW LUGS WITH THE D3405-041 AND D3405-043 LUG ASSEMBLIES.
- c) AMEND THE PARTS LIST IN SECTION 5.0 OF INSTALLATION INSTRUCTIONS IIN-D209-669 REV. B AS SHOWN ON PAGE 2 OF THIS DSI.

NOTE: ALL INSTALLATION FASTENERS FOR THE ABOVE CHANGES HAVE BEEN UPDATED. SEE THE AMENDED PARTS LIST ON PAGE 2 FOR DETAILS.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84911 12/05/30

A	NEW ISSUE		AJS	09.02.24
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.	N/A	DSI 9450	SHEET 1 OF 3	
APPROVED		TITLE	SCALE	
DE APPR.		SKIDTUBE INSTALLATIONS	NTS	
DATE	09.02.24	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.0 PARTS LIST

IS:

50	4	4	1	1		D3405-041	LUG ASSEMBLY
51	8	8	4	4		AN4C47A	BOLT
52	16	16	8	8		D2570	BUSHING
53	8	8	4	4		MS21043-4	NUT
54			1	1		D3405-043	LUG ASSEMBLY
60	1	1	1	1		D3407-041	TOW RING ASSEMBLY
61	1	1	1	1		D3456-1	WASHER
62	1	1	1	1		MS21043-4	NUT
63	2	2	2	2		D3417-5	WASHER

WAS:

50	4	4	1	1		D2736-1	GHW LUG
51	8	8	4	4		AN4-46A	BOLT
52	16	16	8	8		D2570	BUSHING
53	8	8	4	4		MS21042L4	NUT (OR MS21042-4)
54			1	1		D2736-3	GHW LUG
60	1	1	1	1		D2968-041	TOW RING
61	1	1	1	1		AN970-4	WASHER
62	1	1	1	1		MS21042L4	NUT (OR MS21042-4)

DESIGN	A/S	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	A/S		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9450	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SKIDTUBE INSTALLATIONS	NTS
DATE	09.02.24	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

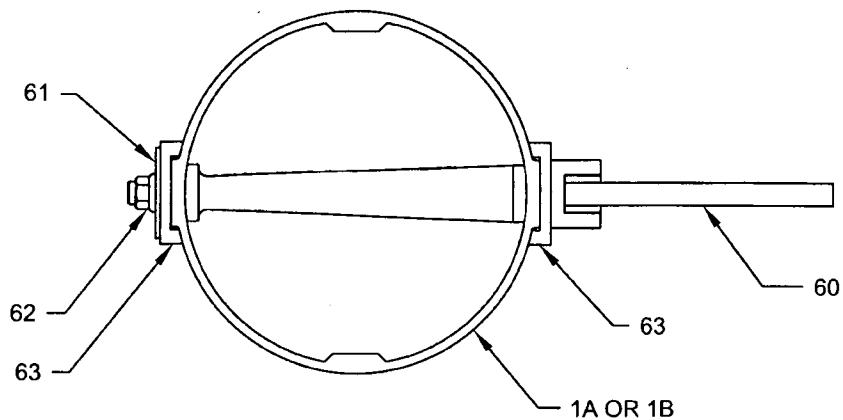
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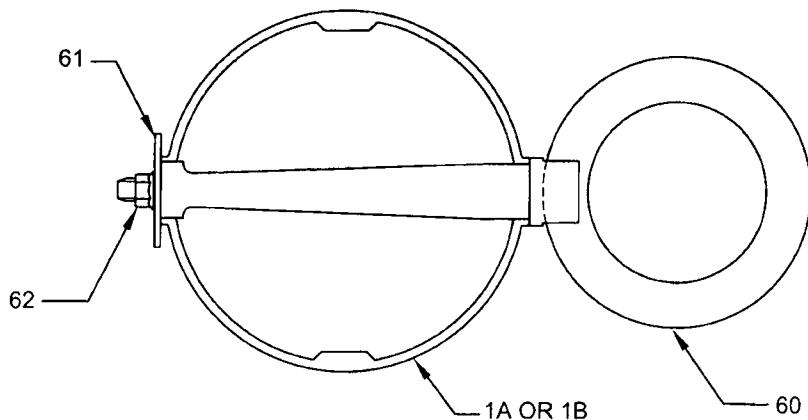
NOTE: Date & initial all entries

INSTALL TOW RING ASSEMBLY AS SHOWN BELOW (REFER TO SECTION F-F OF IIN-D209-669 REV. B.

IS:



WAS:



NO PICTORIAL CHANGE REQUIRED FOR GROUND HANDLING WHEEL LUG CHANGES.

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9450	SHEET 3 OF 3
APPROVED	MJ	TITLE	SCALE
DE APPR.	H	SKIDTUBE INSTALLATIONS	NTS
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11610

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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